

Work Order ID 55598

January 22, 2010 2:36:04 PM



Page 1

Item ID: D2056

Revision ID:

Item Name: Bell Crank

Start Date: 1/22/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2056

Rev B2

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jcaspa Bandsaw

Cut blanks 2.80" long

SA 10/01/23

10

✓

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio D2056
Tumble
Deburr

SA 10/01/24

10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

SA 10/01/24

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55598

January 22, 2010 2:36:04 PM



Item ID: D2056

Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8P 10/01/25

10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M 10/01/25

(X10) 0

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

1105642

=> M 10-01-29

(X10) 0

START TIME:

9:15AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:45AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55598

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Item ID: D2056

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Item Name: Bell Crank

Start Date: 1/22/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BL 10-01-29 @ 10 4.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 6

0.00

Memo

0.00

10x

10-1-29 54

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/02

MF 10-1-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 22, 2010 2:36:03 PM

Page 1

Work Order ID: 55598



Parent Item: D2056

Parent Item Name: Bell Crank

Start Date: 1/22/10

Required Date: 1/29/10

Comments: IPP E 02.04.04 Added Rev.B2 NG

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	54.8800	2.5000			



6061-T6 Bar 1.25 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

54.88

106259

14

109058

21.43

110001

19.45

2.500

86 10/01/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55598
Description: Bell Crank		Part Number:	D2056
Inspection Dwg: D2056	Rev: B2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	0.755	✓			
0.900	+/-0.010	0.904	✓			
1.000	+/-0.010	0.997	✓			
0.125	+/-0.010	0.123	✓			
0.060	+/-0.010	0.058	✓			
Ø0.191	+0.005/-0.001	0.1935	✓			
0.362	+/-0.010	0.355	✓			
0.750	+/-0.010	0.754	✓			
0.385	+/-0.010	N/A	✓			
Ø0.257	+0.006/-0.001	0.259	✓			
0.100	+/-0.010	0.100	✓			
0.300	+/-0.010	N/A	✓			
0.946	+/-0.010	N/A	✓			
0.750	+/-0.010				N/A	10.01.25
0.075	+/-0.010	N/A	✓			
2.637	+/-0.010	2.639	✓			
0.375	+/-0.010	0.375	✓			
Ø0.513-0.518	0.513 - 0.518	0.5165	✓			
R0.450	+/-0.010	.450	✓			
R0.125	+/-0.010	.125	✓			
R0.200	+/-0.010	.200	✓			
R0.550	+/-0.010	.550	✓			
R0.263	+/-0.010	.263	✓			

Measured by:	DTA
Date:	10/01/24

Audited by:	LB
Date:	10/01/25

Prototype Approval:	N/A
Date:	N/A

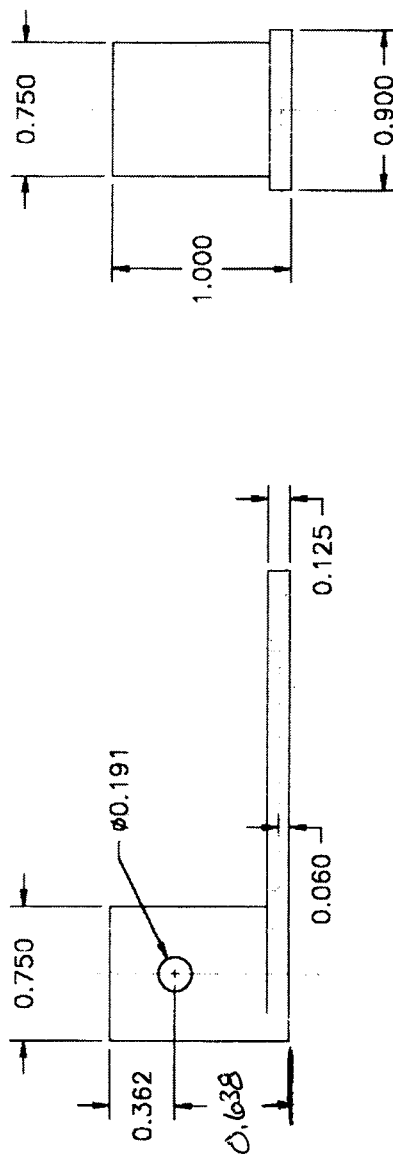
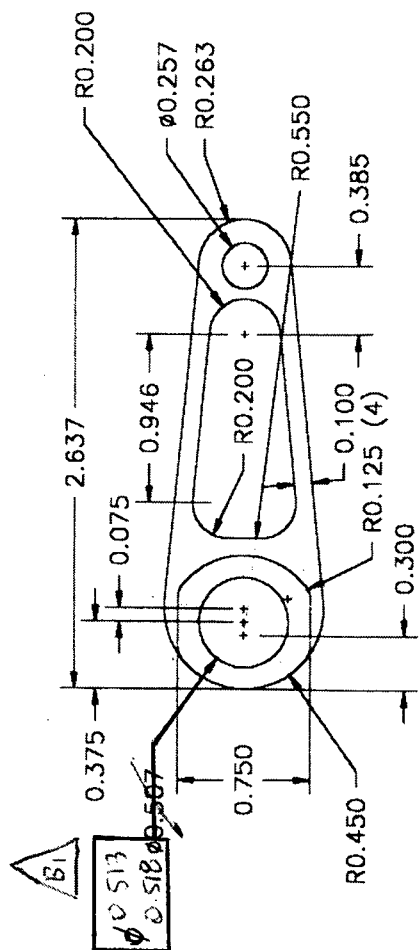
Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	DD



DESIGN		DRAWN BY		DART AEROSPACE LTD	
B WILLIAMS		K HAND		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>		APPROVED <i>KE</i>		DRAWING NO. D2056	
DATE		TITLE		REV. B SHEET 1 OF 1	
92:03:13		BELL CRANK		SCALE 1:1	
B	95:11:02	RE-DESIGN			
B1	<i>P#</i> 01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION			
B2	<i>P#</i> 01.12.20	ADD NOTE ON TOLERANCES			

99.64.24, 14E

Wassers



ACID ETCH + ALUMINE PER
DIESET CASE NOS 4, 1
PUMPER WITH BUTTER SIMILAR
(4, 3, 5, 7) PER DIESET
CASE NOS 4, 3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) ~~OR~~

TOURNAIRES KEEPER FOR MOST USE OF UNLESS OTHERWISE NOTED